

Work Order ID 74721

Wednesday, October 05, 2011 1:58:01 PM



Page 1

Item ID: D2975

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 10/5/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 8.00

Customer:

Reference:

Approvals:

Process Plan: M.L.J

Date: 11/10/05

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2975

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2975 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-

Deburr if necessary 11-10-08

B11-10-25

11

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-10-25

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

m 11 10 28 11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC	NC BRAKE	0.00				(11)			
Brake NC	Memo Deburr if necessary <input type="checkbox"/> Form as per dwg D2975 using DT8261 & DT8326	0.00							
140 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
150 Large Fab	Large Fab	0.00				(11)			
Large Fab	Memo Weld hard surface using DT8210 as per Dwg D2975 & QSI 004 <input type="checkbox"/> Qty Description Batch <input type="checkbox"/> A/R 7560 Hardcoat Rod <u>M117741</u>	0.00							

11/10/29

11 10 31

11 MAY 02 11/11/17

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Required Date: 10/14/2011 Req'd Qty: 8.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

170

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Powder Coating

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

0.00

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Cust Item ID:
Customer:

QC

Quality Control

170

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Powder Coating

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

0.00

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11X Ø M-L 11/11/17

11 BR 11 11 17

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: 81497A	0.00							
	Packaging	Memo							
Packaging									
200	QC21 - Final Inspection - Work Order Release	0.00							
	QC	Memo							
Quality Control									

(11X) SP 11-11-18

11/11/21

11-11-18

W/O:		WORK ORDER CHANGES						
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Picklist Print

Wednesday, October 05, 2011 1:58:06 PM

Page 1

Work Order ID: 74721

Parent Item: D2975

Parent Item Name: Wearshoe



Start Date: 10/5/2011

Required Date: 10/14/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: C02.10.23 Re-format KJ
IPP Rev:D Now on Waterjet 06-11-21 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M1010S16GA		Purchased	No			100	sf	92.7000	0.2758	2.322526			
------------	--	-----------	----	--	--	-----	----	---------	--------	----------	--	--	--



1010/1025 sheet 16GA



1311-10-25

Location

Loc Qty

Loc Code

MAT019

92.7

116791

28.9

117500

31.8

118965

32

117500

11

W/O:		WORK ORDER CHANGES					
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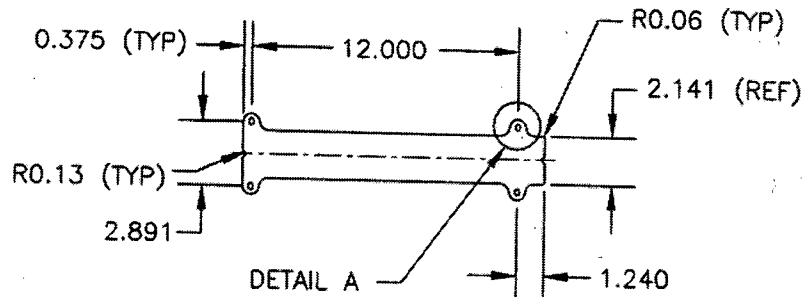
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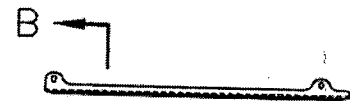


DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2975	REV. A SHEET 1 OF 1
DATE 00.03.10		TITLE WEARPLATE	SCALE 1:8
A	00.03.10	NEW ISSUE	

FLAT PATTERN

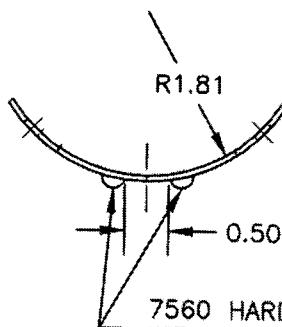


BENDING DETAIL



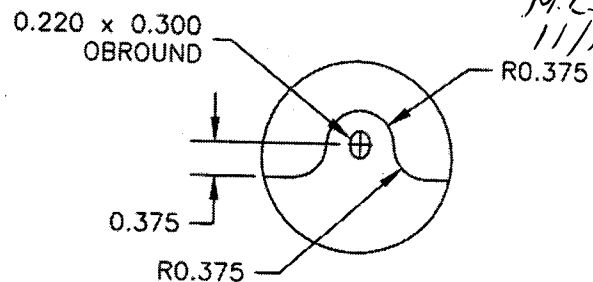
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

SECTION B-B SCALE 2:5



7560 HARDCOAT WELDS TO
WITHIN 0.25 OF WEARSHOE
ENDS 0.063 TO 0.125 THICK

DETAIL A SCALE 2:5



WORK ORDER
NO. 74721

M.C. J
11/10/05

RELEASED
00.05.11 [Signature]

BREAK ALL SHARP EDGES 0.010 TO 0.020
MATERIAL: AISI 1010-1025 OR ASTM A36/A366 SERIES STEEL
16 GAUGE (0.063 THICK)
FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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